

Work Order ID 84703

May-22-12 9:22:31 AM

84703

Page 1

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 29/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/22 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	I

100	MORI SEIKI CNC LATHE LARGE	0.00							
100	Mori Seiki	0.00							
	Mori Seiki CNC Lathe Large								
	Memo								
	Turn as per Folio FA599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>H</u>								
	scribe batch # on fwd end at 90 degree								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
	Quality Control								

111	QC8- Inspect parts - second check	0.00							
111									
QC	Memo	0.00							
	Quality Control								
	INSPECT INSIDE BORE								

Da 12/05/29

KC / 9mm L
12/05/24

KC / 9mm L
12/05/24

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/18	160	height after bending over tolerance (+0.325 over nominal)	GP 12/6/18	Acceptable. Additional height increases drag moment, which counteracts vert. float load	CF	DP 12-6-21	GP 12/6/18	

NOTE: Date & initial all entries

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Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 22/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: De & Dwg D3391 Rev: I
2-Debur

B.O. 12/05/29

130

0.00

130

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.O. 12/05/29

140

0.00

140

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

INSPECT INSIDE BORE

24 12/05/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
160	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170		0.00							
170	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

① SMO 12-05-31

De 12/08/31

DP 12-8-21
as per PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180	Skidtubes					<u>1</u>	<u>0</u>	<u>CF12-62</u>	
Skidtubes	Memo	0.00							
Skidtubes	1 Open Aft cap pilot hole to .208" as per Dwg D3391								
	2 Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3 Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .								
	*****Do Not Open To Finished Size*****								
	4 Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5 Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6 Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7 Deburr								

1 2 CF 12-6-22

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Chemical Conversion Coat per QSI005 4.1	0.00							
200									
HandFinish	Memo	0.00							
Hand Finishing									
210	QC7-Inspect Chemical Conversion Coat	0.00							
210									
QC	Memo	0.00							
Quality Control									

1 M 12-6-24

i NG 12-6-25

DP 12-6-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>120666</u> exp. date: <u>13-1-30</u> cure time 12hrs as per QSI0015								
230	QC5- Inspect part completeness to step on W/O	0.00							
230		0.00							
QC	Memo	0.00							
Quality Control									
235	Pressure Wash per QSI005 4.3	0.00							
235		0.00							
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

12-6-25

5/2/04/26

1 7/6 12-6-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:
Item Name: Aft Tube Assembly

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N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 22/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:00 OVEN TEMPERATURE: 300 FINISH TIME: 11:30								126-27
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							126-27
Quality Control									
260	HandFinishing	0.00							
260									
HandFinish	Memo	0.00							126-27
Hand Finishing	1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/R Sikaflex-241/-291 M121409 Sikaflex expiry date: 13/03 3- INSTALL WEARPLATES AS PER DWG								

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Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 *270* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 16	12/6/26					
280 *280* Packaging Packaging	Identify as per dwg & Stock Location: <u>wlo</u> Memo	0.00 0.00	D 412-742-043/1387072			1x	4	HL 12/08/26	
290 *290* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						CK 12/8/27 -	MF 12-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 84703

84703

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:
 IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	11.0000	1	1			
D4095-047								1385498	**				
Wearpad Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				11					
				81626				11					
D4095-049		Manufactured	No			260	Each	19.0000	1	1			
D4095-049									**				
Wearpad Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				19					
				81612				19					
D6014-090		Manufactured	No			100	Each	68.0000	1	1			
D6014-090									**				
ALUMINUM EXTRUSION													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				68					
				77332				26					
				79742				42					

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 84703

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

85.0000

4

4

D3670-4-200

SPACER

**

DP 12-6-25

Location

Loc Qty

Loc Code

LG

84504

40

80360

40

LG001

45

78606

4

81972

41

(4)

D2646

Manufactured No

270

Each

35.0000

1

1

D2646

Aft Cap

**

HL 12/06/27

Location

Loc Qty

Loc Code

FP002

35

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

5

79562

14

B85443

X1

D3672-1

Manufactured No

270

Each

1,206.000

2

2

D3672-1

Phenolic Washer

**

HL 12/06/27

Location

Loc Qty

Loc Code

ST060

1206

72229

4

76277

202

80369

500

83608

500

X2

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

3,253.000

14

14

AI S4-1032-130

Insert

**

11 1106/23

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

174

120807

36

120837

138

ST282

2874

121269

2874

114

ALS4-1032-225

Purchased

No

270

Each

888.0000

8

8

AI S4-1032-225

Insert

**

121 1107/04

Location

Loc Qty

Loc Code

ST281

865

108696

146

110768

62

118386

55

118966

68

121269

534

11122290

12

ST282

23

120410

10

120451

13

Dart Aerospace Ltd

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Parent Item Name: Aft Tube Assembly

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

270 Each 1,941.000 6 6

AN3C4A

BOLT

**

HL 12/06/27

Location

Loc Qty

Loc Code

ST350

1941

120187

57

120521

28

120769

38

121205

1000

121556

818

XL

AN3C5A Purchased No

270 Each 1,348.000 4 4

AN3C5A

Bolt

**

HL 12/06/27

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1341

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255

500

121444

228

121708

500

XL

AN960C10L NAS1149C0332 Purchased No

270 Each 0.0000 10 10

*AN960C10I *

washer

HL 122063

**

(x10) HL 12/06/27

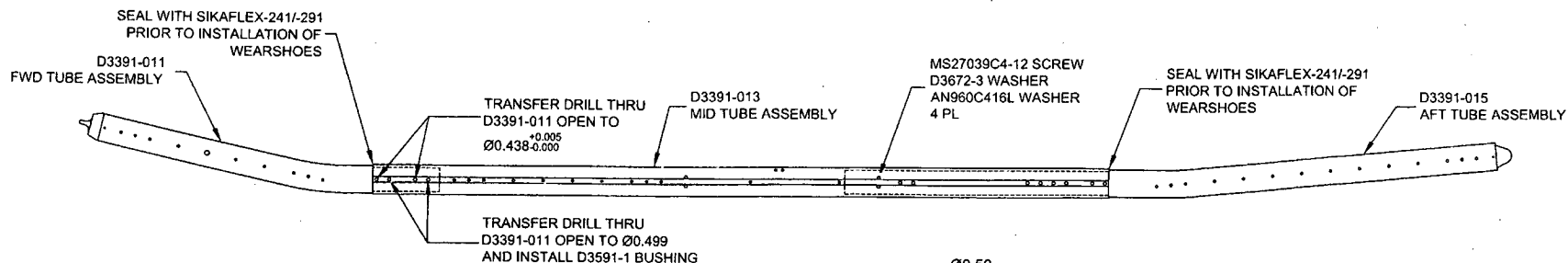
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D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 24703 MW
12/05/22

D3391-041 ASSEMBLY

RELEASED
2011-11-04
ECN# 11-662

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL, ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL, ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
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MFG. APPR.		D3391	SHEET 1 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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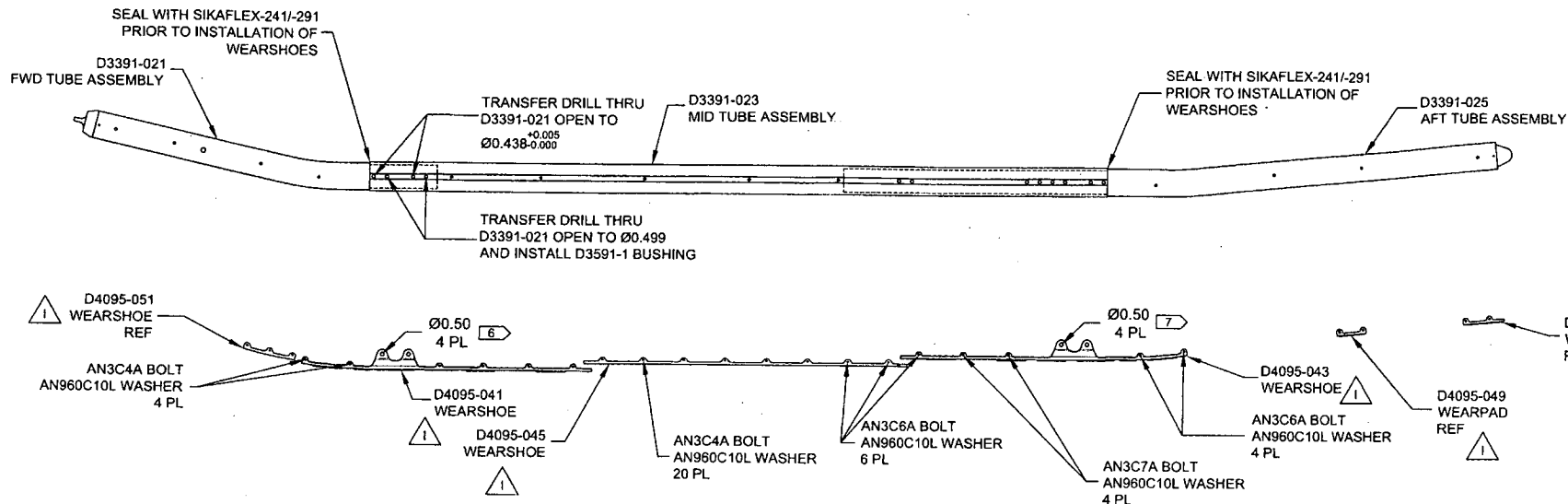
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84703



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
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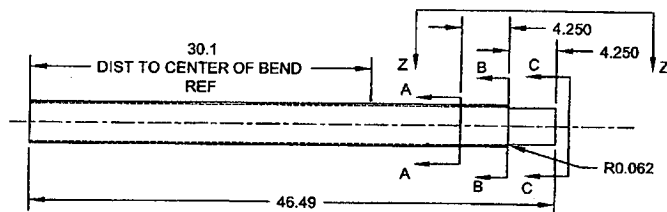
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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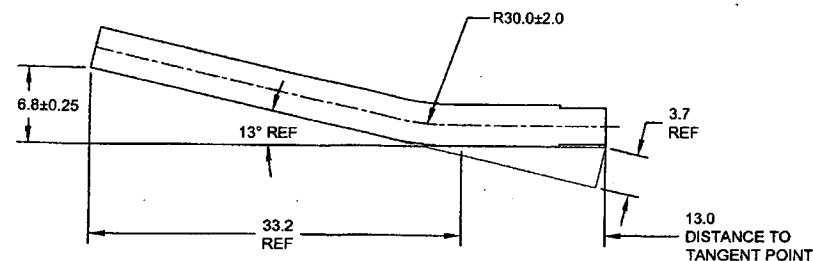
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

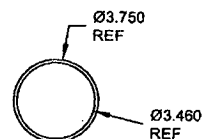
NOTE: Date & initial all entries



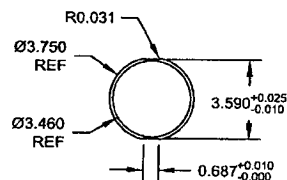
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



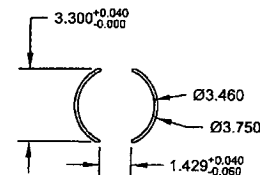
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



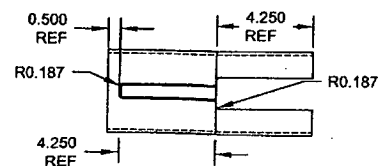
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
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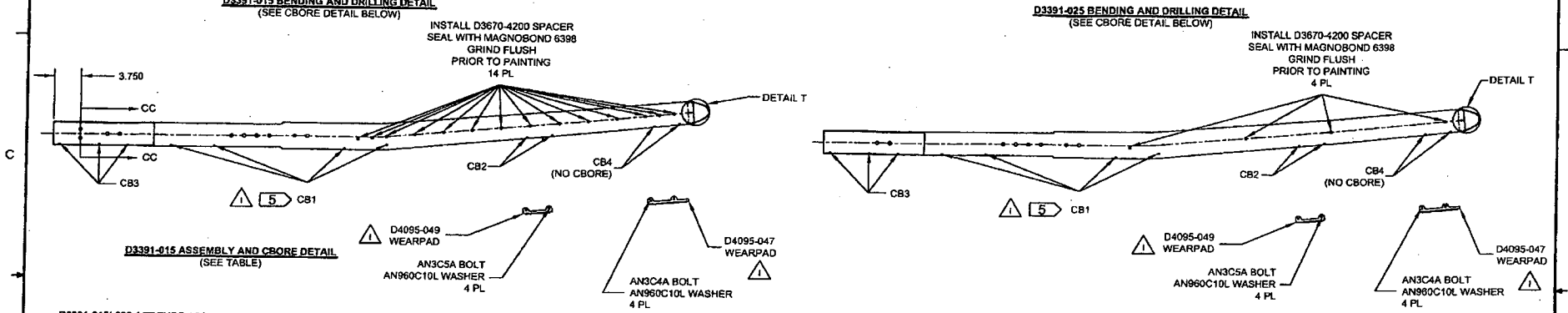
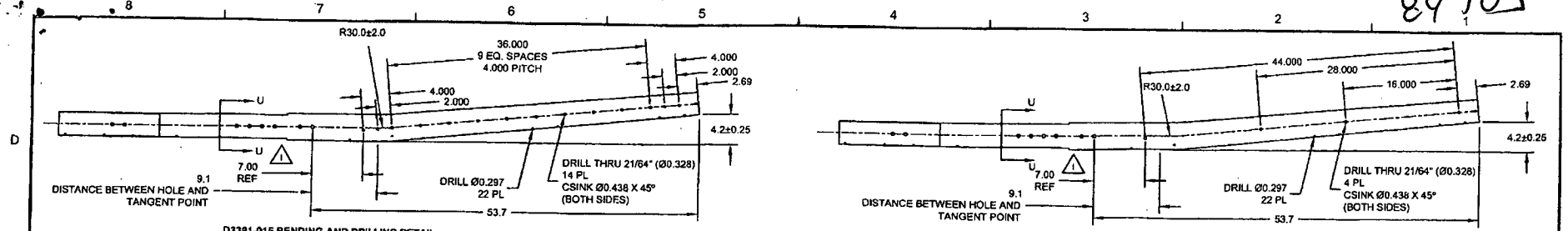
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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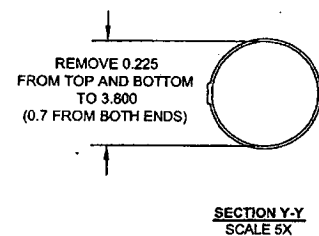
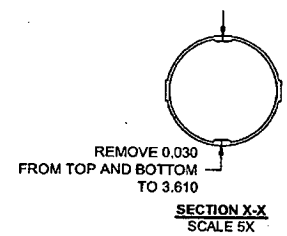
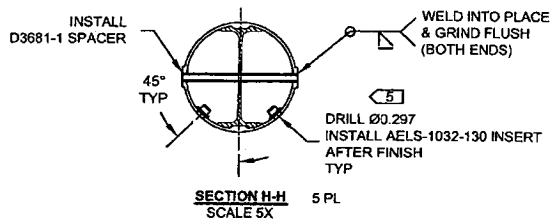
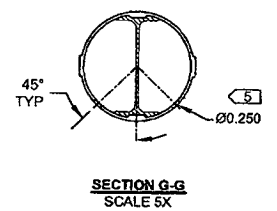
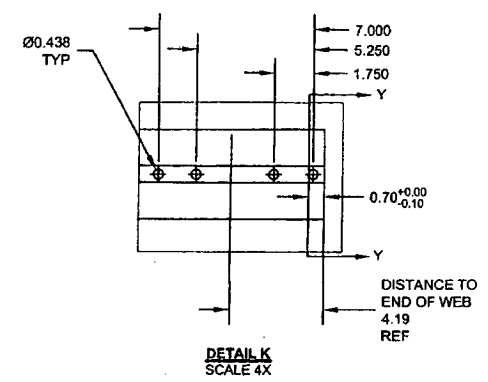
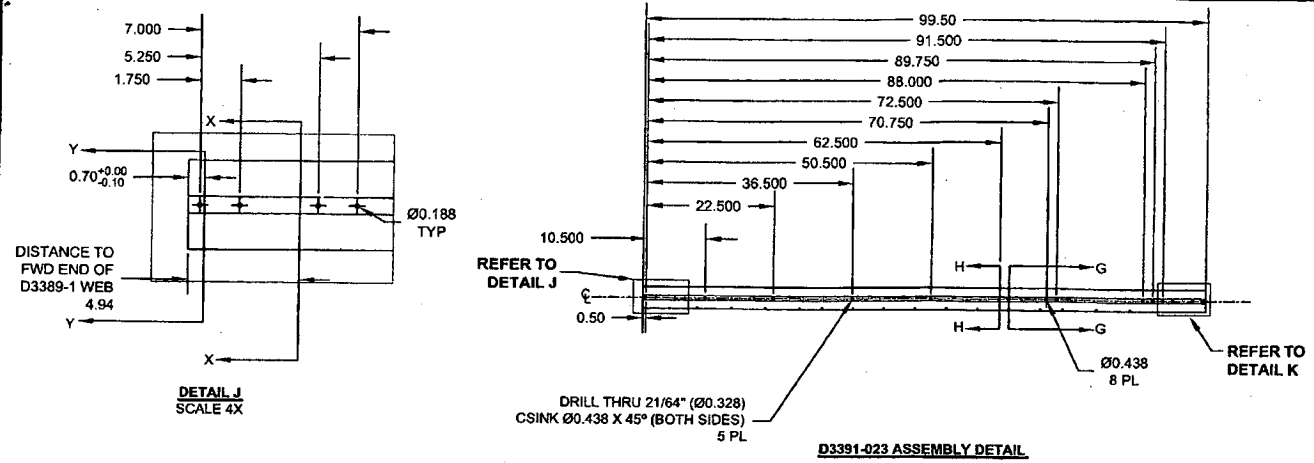
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D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:
Dat Aerospace

SPACE LTD	Work Order: 87703
Part Name: Float Skidtube (412)	Part Number: D3391-3
Section Dwg: D3391 Rev: I	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		tape	ED-11
3.500	+/-0.010	3.504	✓		vern	CWC-08
88.93	+/-0.030	88.96	✓		tape	ED-11
Ø3.200	+/-0.010	3.201	✓		vern	CWC-08
88.93	+/-0.030	88.96	✓		tape	ED-11
Ø3.750	+/-0.010	3.750	✓		vern	CWC-08
30° x 160° chamfer	+/-0.010	30° x 160°	✓		"	

Measured by: KC / MAM	Date: 12-5-22
Audited by: MK	Date: 12/05/23

HAAS Section						
1.526	+0.000/-0.030	1.516	✓		Vern	GA-01
7.500	+/-0.010	7.500	✓		Vern	CNC-02
27.750	+/-0.010	27.750	✓		Tape	GA-12
31.750	+/-0.010	31.750	✓		"	"
35.250	+/-0.010	35.250	✓		"	"
3.300	+/-0.010	3.301	✓		Vern	GA-01
0.200	+/-0.010	0.200	✓		"	"
3.520	+/-0.010	3.516	✓		"	"
0.687	+0.010/-0.000	0.687	✓		"	"
R0.062	+/-0.010	R0.063	✓		R-6	ref.
Ø0.484	+0.005/-0.001	Ø0.489	✓		Vern	GA-01

Measured by: D.A	Date: 12/05/29
Audited by: MK	Date: 12/05/23

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	

WORK ORDER CHANGES

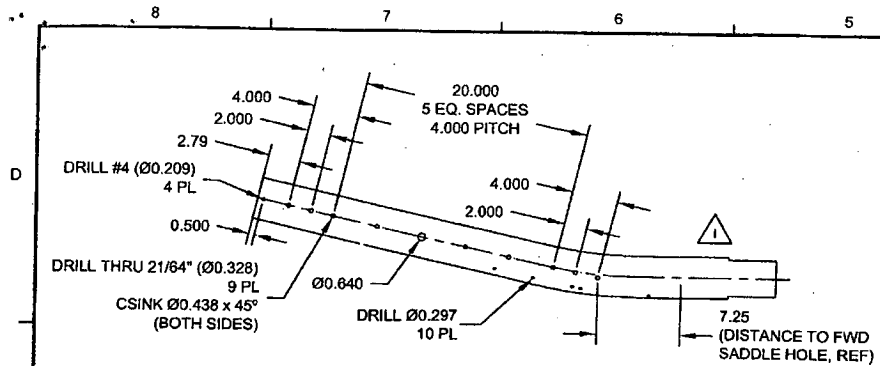
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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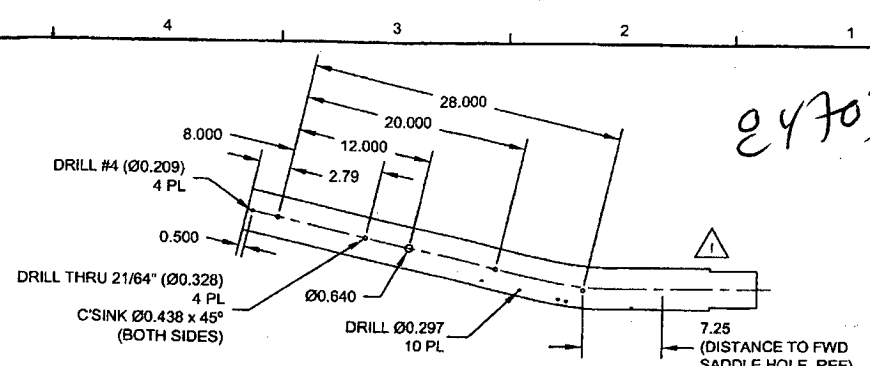
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

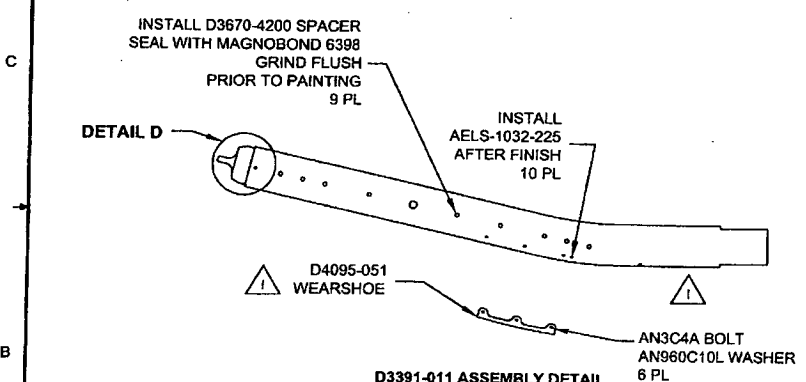
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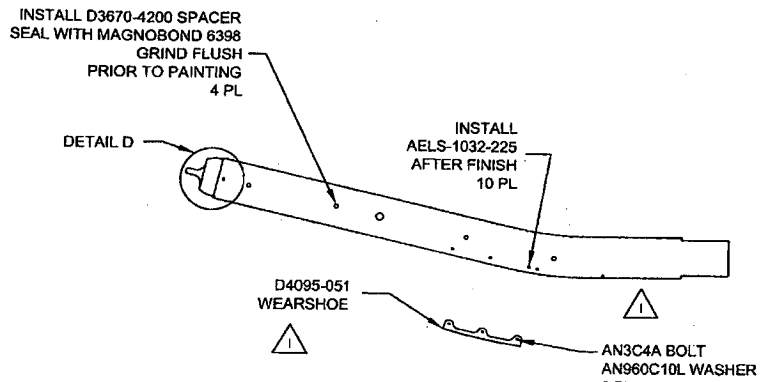
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



D3391-011 ASSEMBLY DETAIL

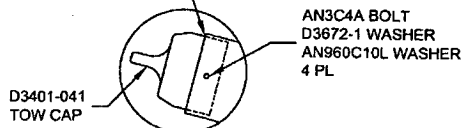


D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT

SEAL WITH SIKAFLEX-241/-291



DETAIL D SCALE 2X

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

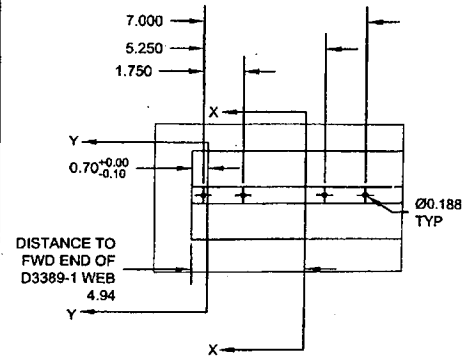
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

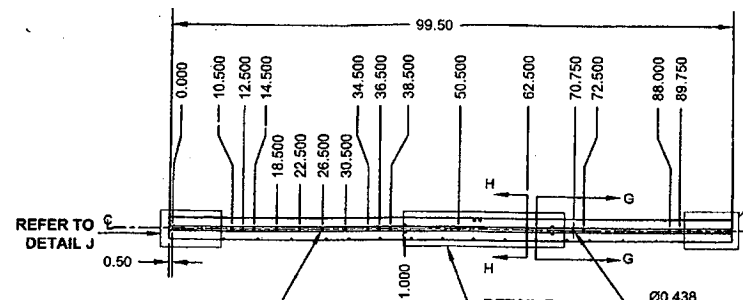
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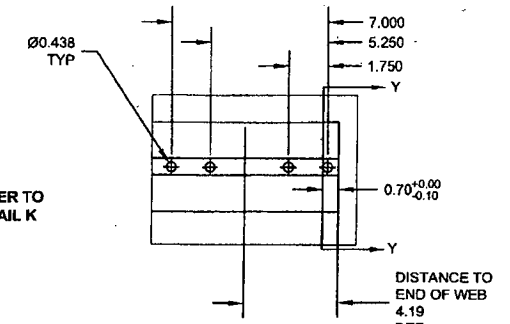
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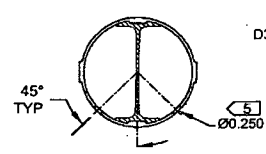
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SCALE 4X



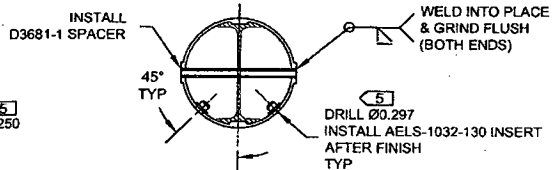
D3391-013 ASSEMBLY DETAIL



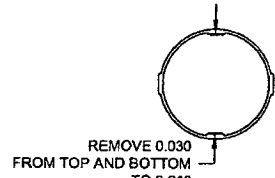
DETAIL K
SCALE 4X



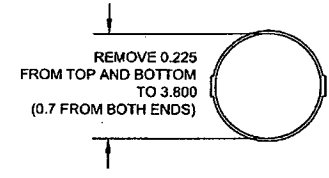
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



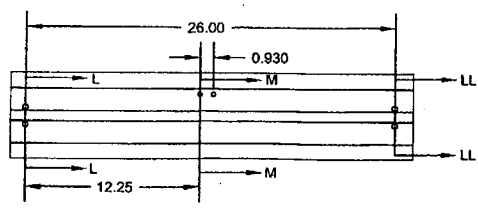
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

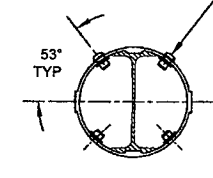
QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

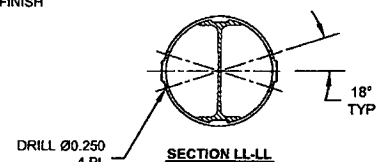
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004



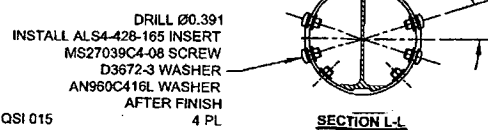
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



SECTION L-L
SCALE 5X

RELEASED
2011-11-04

DESIGN	RH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

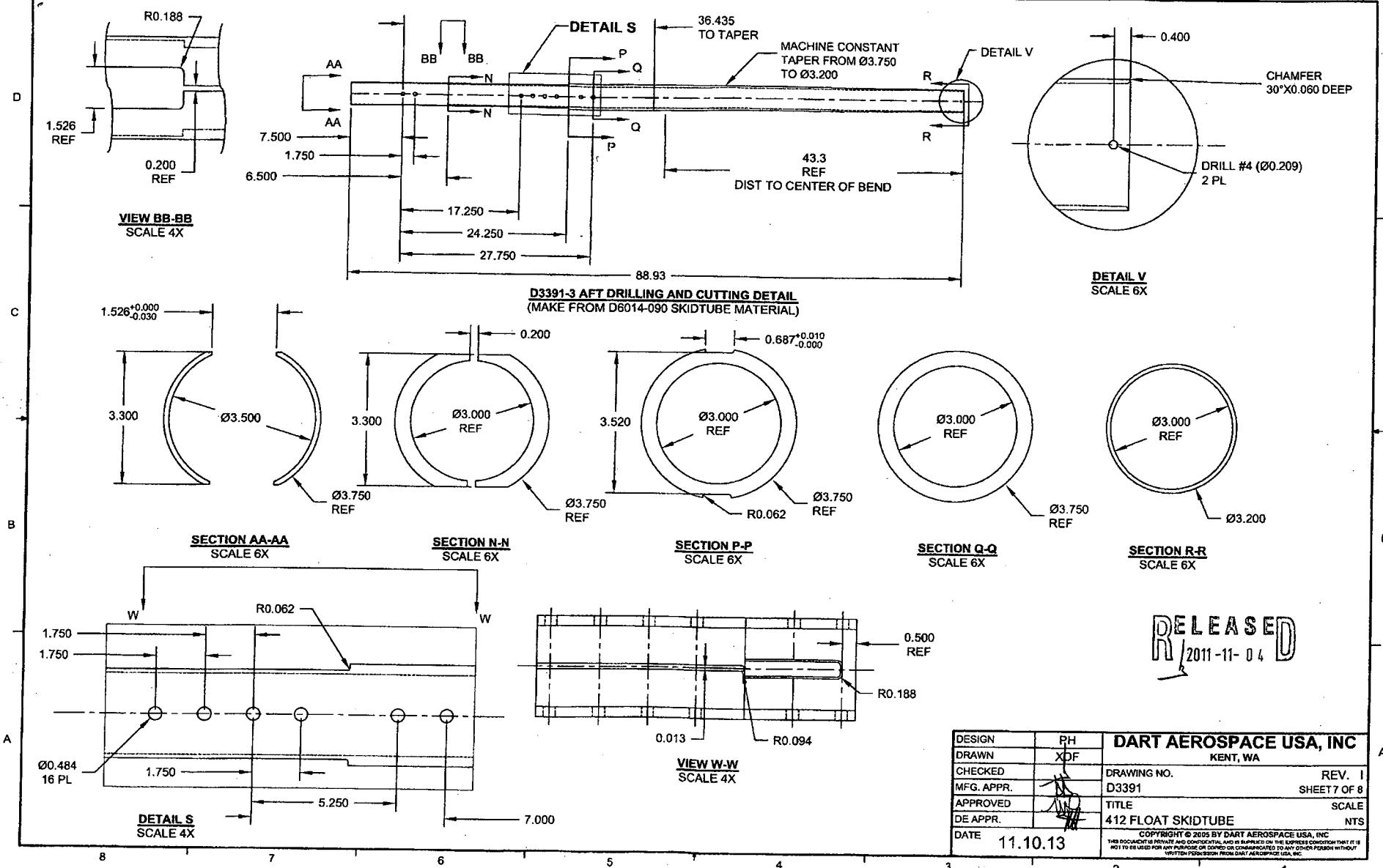
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24703



DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries